

Work Order ID 47325

June 26, 2009 4:24:41 PM



Page 1

Item ID: D412-758-013
 Revision ID: A
 Item Name: GPS Receiver Gimbal Mount, Top Mounted

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 2.00
 Required Date: 03/08/2009 Req'd Qty: 2.00



Cust Item ID:
 Customer:

Reference:

Approvals: Process Plan: *WV*
 QC:

Date: *15/7/09*
 Date:

Tooling:
 SPC (Y/N):

Date:
 Date:

Run Start
 Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev A

100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP412-758-013	CHG001							

8/2/10/01

4/ for JLD 09/05/11

9/10/15 SP (24)

110	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

→ QCL inspect kit for complete new

2/ 8/2/10/01

(X) 4

120	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-758-013								
	CHG001 Location: _____	PPP Rev: <i>A</i>							

Pack/10/02 (2)

Work Order ID 47325

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Item ID: D412-758-013

Accept



Setup Start



Revision ID: A

Stop



Item Name: GPS Receiver Gimbal Mount, Top Mounted

Start Date: 15/07/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/05

U 09-10-02

Picklist Print

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Page 1

Work Order ID: 47325

Parent Item: D412-758-013RevA

Parent Item Name: GPS Receiver Gimbal Mount, Top Mounted

Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN525-10R7 Screw		Purchased	No			120	Each	268.0000	8.0000			
AN960JD10 Washer		Purchased	No			120	Each	1,246.000	8.0000			
D2464RevB 3/4 Seal		Manufactured	No			120	f	896.4300	2.2105			
D3514-043RevA Top Mounted Gimbal Assembly		Manufactured	No			120	Each	0.0000	2.0000			
D3525-1RevA Placard		Manufactured	No			120	Each	19.0000	2.0000			
D3534-1RevA Doubler		Manufactured	No			120	Each	17.0000	2.0000			
D3645-1RevA Washer		Manufactured	No			120	Each	181.0000	8.0000			
MS24693-S27 SCREW		Purchased	No			120	Each	28.0000	8.0000			

M112411 SP

M112369 SP

B48173 SP

47430 SP

B28428 SP

B35360 B347431 SP

B35004 SP

M101760 SP

911011 SP

Cut qty of 2 @ 6.600" per dwg
*** per kit ***

Site: Monday, 20/04/2009 2:40:46 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TOP MOUNTED GPS RECEIVER GIMBAL MOUNT
Job Number	: 47325		
Estimate Number	: 12886		
P.O. Number	:	Part Number	: D412758013
This Issue	: 20/04/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: N/A
First Issue	: / /	Project Number	: N/A
Previous Run	: 45418	Drawing Revision	: A
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 15/05/2009
Checked & Approved By	: <u>JUL 09.04.20</u>	Qty:	2 Um: Each
Comment	: est rev A 07.05.28 new issue EC verified by DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

✓ DC

DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPP412-758-013 CHG001

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0

✓ D3514043

Top Mounted Gimbal Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

TOP MOUNTED HOUSING ASSEMBLY

batch: _____

4.0

✓ D2464

3/4 Seal



Comment: Qty.: 1.1025 f(s)/Unit Total : 2.2050 f(s)

3/4 Seal

Cut Qty 2 seal 6.60" long (D2464-0066)

QTY 2 Batch: _____

5.0

✓ D35251

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLACARD

batch: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 20/04/2009 2:40:46 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP MOUNTED GPS RECEIVER GIMBAL MOUNT

Job Number: 47325

Part Number: D412758013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0



D35341

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
DOUBLER

batch: _____

7.0



D36451

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
WASHER

Batch: _____

8.0



AN52510R7

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
Screw

batch: _____

9.0



AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
Washer

batch: _____

10.0



MS24693S27

SCREW



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)
SCREW

batch: _____

11.0



QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

12.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-758-013 CHG001

Location: _____

PPP Rev: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 20/04/2009 2:40:47 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP MOUNTED GPS RECEIVER GIMBAL MOUNT

Job Number: 47325

Part Number: D412758013

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

✓ QC21

FINAL INSPECTION/W/O RELEASE



✓ Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE

The following weight and balance information does not include the installation of the GPS Receiver in the D412-758-011/-013 Gimbal Mount.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-758-011 , Bottom Mounted GPS Receiver Gimbal Mount	1.40 lb 0.64 kg	8.0 in 0.20 m	11.2 in lb 0.13 kg m	24.0 in 0.61 m	33.6 in lb 0.39 kg m
D412-758-013 , Top Mounted GPS Receiver Gimbal Mount	1.37 lb 0.62 kg	0 in 0 m	0 in lb 0 kg m	24.0 in 0.61 m	32.9 in lb 0.38 kg m
Typical Antenna Installation	0.5 lb 0.23 kg	-10.5 in -0.27 m	-5.3 in lb -0.06 kg m	51.5 in 1.31 m	25.8 in lb 0.30 kg m

5.0 PARTS LIST

QTY -011	QTY -013	Part Number	Description
X		D412-758-011	Bottom Mounted GPS Receiver Gimbal Mount
	X	D412-758-013	Top Mounted GPS Receiver Gimbal Mount
1		D3514-041	Bottom Mounted Gimbal Assembly
	/ 1	D3514-043	Top Mounted Gimbal Assembly
1		*D3514-045	Bottom Mounted Housing Assembly
	1	*D3514-047	Top Mounted Housing Assembly
1	1	*D3522-1	Gasket
1		*D3523-1	Leg
	1	*D3523-3	Leg
1	1	*D3524-1	Lower Plate
1	1	*D3526-1	Rubber Seal
	1	*D3531-041	Bracket Assembly
2	2	*D3533-3	Set Screw
	1	*AN3-6A	Bolt
1		*AN3-10A	Bolt
3	2	*AN960JD10L	Washer
4	4	*MS24693-S29	Screw
	(2	D2464-0066	Neoprene Seal
1	(1	D3525-1	Placard
1		D3527-1	Support Arm
1		D3530-1	Base Plate
1		D3530-3	Mounting Plate
1	(1	D3534-1	Doubler
	/ 4	D3645-1	Washer
	(4	AN525-10R7	Screw
3		AN526-632R7	Screw (or MS35206-229)
3		AN960JD6	Washer
2	(4	AN960JD10	Washer
3		MS21042L06	Nut
1		MS21042L3	Nut
4	4	MS24693-S27	Screw
1		MS27039-1-09	Screw

Note: * denotes included in above assembly